



Insert Part Number		3732-1HD
Military Specification		MS51831-111
Reference Number		KNH1608J
Insert Type		Heavy Duty
Internal Thread Form		UNJC
Internal Thread Size		1-8
External Thread Size		1.3/8-12
Nominal Length Q	inch	1.375
Insert Material		Stainless Steel - 303 CRES
Insert Finish		Passivated
Insert Coating		-

Loksert solid keylocking inserts are an easily installed thread assembly that are ideal for replacing damaged or worn threads in virtually any material - ferrous, non-ferrous and non-metallic. They are constructed from high quality carbon steel or extremely hard wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration - such as mining, construction and earthmoving equipment.

COMPATIBLE LOKSERT INSTALLATION AND REMOVAL TOOLS	
TOOL TYPE	Part #
Hand Installation tool - Miniature	-
Hand Installation tool - Thin Wall	-
Hand Installation tool - Heavy Duty	3600-1HT
Hand Installation tool - Universal (TW & HD)	3600-100T
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	-
Pneumatic Tool	-

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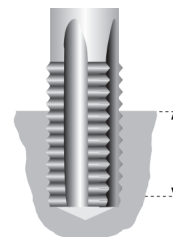
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

A Tapping Drill Size	mm	-
A Tapping Drill Size	inch	1-5/16
Tapping Drill Part Number		3632-1.5/16**



TAPPED HOLE DIMENSIONS

Tap Size		1-3/8-12
Tap Tolerance		2B
T Tapping Depth minimum	mm	-
T Tapping Depth minimum	inch	1.56
Loksert Tap Part Number	Intermediate	3632-1.3/8I
C Countersink Width minimum	mm	-
C Countersink Width minimum	inch	1.395



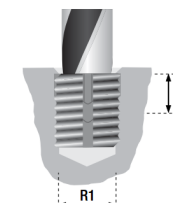
INSERT SPECIFICATIONS

Internal Thread		1-8
Internal Thread Tolerance		3B
External Thread		1.3/8-12
External Thread Tolerance		2A (Mod)
Q Nominal Length	inch	1.375
Locking Keys	#	4



INSERT REMOVAL SPECIFICATIONS

R1 Drill Size	mm	-
R1 Drill Size	inch	1.7/32
R2 Drill Depth minimum	mm	-
R2 Drill Depth minimum	inch	5/16



For detailed removal instructions please visit powercoil.com.au